

	011 8:47:00 AN
Item ID:	D3405-043
Revision ID:	
Item Name:	Lug Assembly

Start Date: 1/24/11

Start Qty: 15.00

Required Date: 2/11/11 Req'd Qty: 15.00



Accept

Setup Start





Reference: Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Cust Item ID:

Customer:

Stop



Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number Stamp

D3405

Draw Nbr

Revision Nbr Rev B

100

Waterjet

FLOW CNC Waterjet 751.125

FLOW WATER JET

Memo

1-Cut as per Dwg D3405 Dwg Rev:

Prog Rev:

0.00

0.00

2-Deburr if necessary

1B(1-1-04



110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



Quality Control

QC8- Inspect parts - second check

Memo

0.00

									
W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	R	esolution:						Date: _ 	
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		Description of NC	C Corrective Action		Section B		ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigı Da	۱& ∣ _{Sec}	tion C	Chief Eng	QC Inspector
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Work Order ID 65703

January 24, 2011 8:47:01 AM



Page 2

Item ID:

D3405-043

Accept

Setup Start

Revision ID:

Start Date:

Lug Assembly Item Name:

Required Date: 2/11/11

1/24/11

Start Qty: 15.00 Req'd Qty: 15.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Run

Start

Stop



QC:

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Accept

Qty

Stop

Reject

Number

Reject

Qty

Insp.

Stamp

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation

Description 3

NC BRAKE

Memo

1-Deburr

2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming 0.00

0.00

SB IIloilaG

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2 Worlze

150

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M107051* 0.00 Large Fab

Memo

Memo

0.00

Weld as per Dwg D3405 use DT8484 Identify as D3405-043

11-3-8 X1



Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	·\$	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Disposition	on:	QA: N/C C	osed:		Date: _	****
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section	n B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	• 1	ion C	Chief Eng	QC Inspector

Work Order ID 65703

January 24, 2011 8:47:01 AM



Page 3

Item ID:

D3405-043

Accept

Setup Start

Stop

Stop



Revision ID:

Start Date:

Item Name: Lug Assembly

Required Date: 2/11/11

1/24/11

QC:

Start Qty: 15.00

Req'd Qty: 15.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run



Sequence ID/

Work Center ID

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

Quality Control

Powder Coating

QC5- Inspect part completeness to step on W/O

Memo

Memo

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: OVEN TEMPERATU

FINISH TIME:

11-07-17 Drab green (Re: 4.3,5.11) per QS1005

15 BR 11-3-9.

0.00

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		W	ORK ORDER CHA	NGES				,
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Res	olution:						Date: _	
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0==0	Description of NC		Corrective Action	Section B	Verifi	cation	Approval	Approval
SIEP	Section A Ini		Action Descript Chief Eng		Date Section (Chief Eng	QC Inspector
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):	PAR #: Resolution: STEP Description of NC Section A	PROCEDURE CH PROCEDURE CH PAR #: Fault Cat Resolution: Dispositi WORK ORI STEP Description of NC Section A Initial Chief Eng	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFOI STEP Description of NC Section A Corrective Action Initial Chief Eng Chief Eng	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NC STEP Description of NC Section A Corrective Action Section B Initial Action Description Sign Chief Eng Chief Eng Date	STEP PROCEDURE CHANGE By Date Disposition: NCR: Yes No DQ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Disposition: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Initial Chief Eng Action Description Chief Eng Chief	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Proof Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: _ Resolution: Disposition: QA: N/C Closed: Date: _ WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC

Work Order ID 65703

January 24, 2011 8:47:02 AM



Page 4

Item ID:

D3405-043

Accept

Setup Start

Stop



Revision ID:

Item Name:

Lug Assembly

Start Date:

Required Date: 2/11/11

1/24/11

QC:

Start Qty: 15.00

Req'd Qty: 15.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling: SPC (Y/N): Date:

Run

Stop

Start



Sequence ID/ **Work Center ID**

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan

Date:

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Quality Control

Packaging

Packaging

Identify as per dwg & Stock Location: 423

Memo

0.00

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE		Description of NC	Corrective Action		tion B	v	erification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		in & ate	Section C	Chief Eng	QC Inspector
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Picklist Print

January 24, 2011 8:47:00 AM

Work Order ID: 65703

Parent Item:

D3405-043

Parent Item Name: Lug Assembly



Start Date: 1/24/11

Required Date: 2/11/11

Page 1

Start Qty: 15.00

0.154

2.431579

70.4003

Required Qty: 15.00

Comments:

IPP A□05.09.01□New issue□KJ/JLM□

IPP B 09.01.28 Rev b dwg EC verified by: DD

Purchased

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1	HI	Manufactured	· No		100	Each	0.0000	1	15			
·GHW Lug			3454	B 65	701	X15			a	11-3-	8	~!*

150

M304S11GA



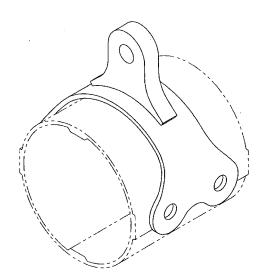
304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	70.4003	
114799	0.5003	
116437	5.9	
116623	64	

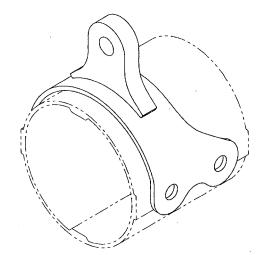
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Part No	:	PAR #:	Fault Ca	legory:	_ NCR: Ye	s No	DQA: _	'	_ Date: _	
		esolution:								
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NO	CR)				
DATE	STEP	Description of NC			ion B	- 0	Verificati		Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Da		Section (C	Chief Eng	QC Inspector
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ا	ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	
Ī	1	Х		D3405-041	LUG ASSEMBLY	
	2		Х	D3405-043	LUG ASSEMBLY	
}	11	1	1	D3404-1	GHW LUG	
Ī	12	1		D3405-1	GHW BRACKET	
Ī	13		1	D3405-3	GHW BRACKET	





D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

Α

REV.

DESIGN

DRAWN



NOTES:

D

1) MATERIAL: N/A
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

CHECKED DRAWING NO. D3405 MFG. APPR APPROVED TITLE

GHW LUG ASSEMBLY DE APPR. DATE 08.09.19

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DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

3

NEW ISSUE

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & 3. INCREASED IN LENGTH TO PREVENT FOULING AT INSTL. (SEE PAR198) SHEETS 3 & 4 ZONE & 6 4. 120 DIM WAS 4. 100.

DESCRIPTION

AJS

PH

BY

08.09.19

05.03.08

DATE

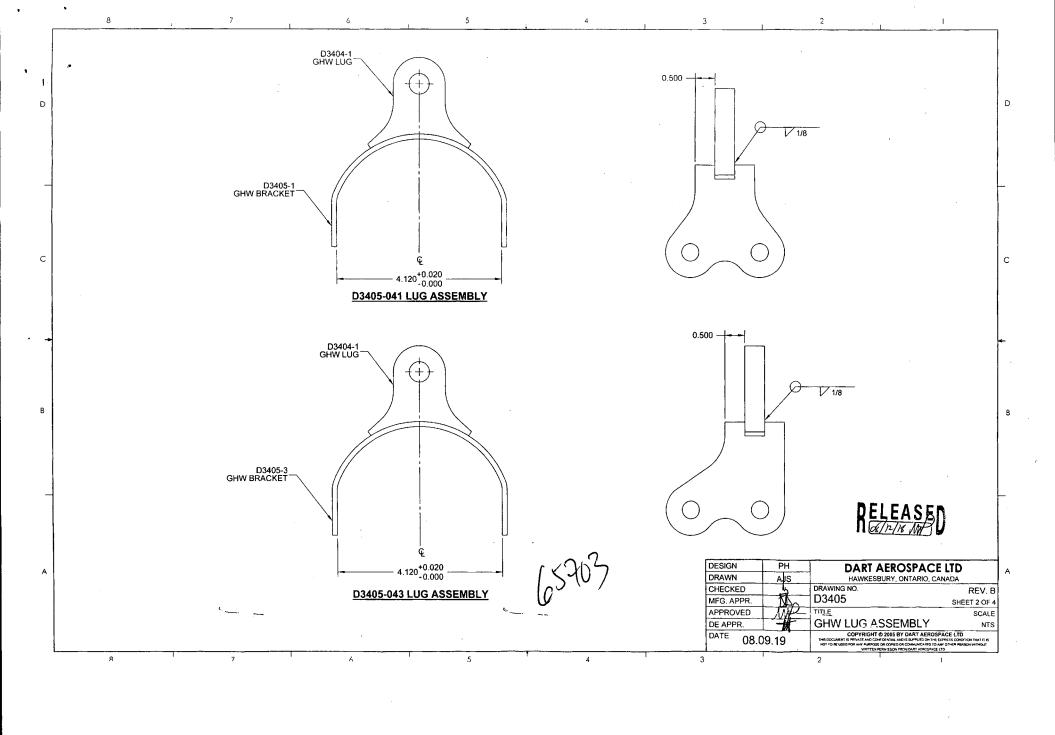
SHEET 1 OF

REV. B

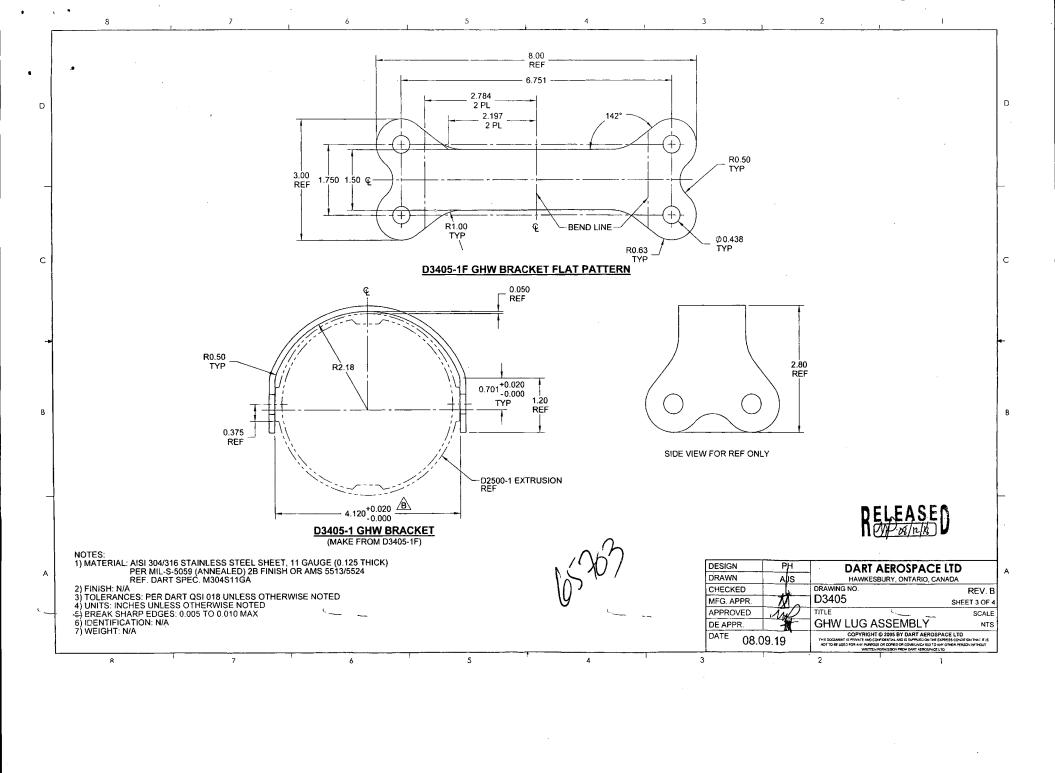
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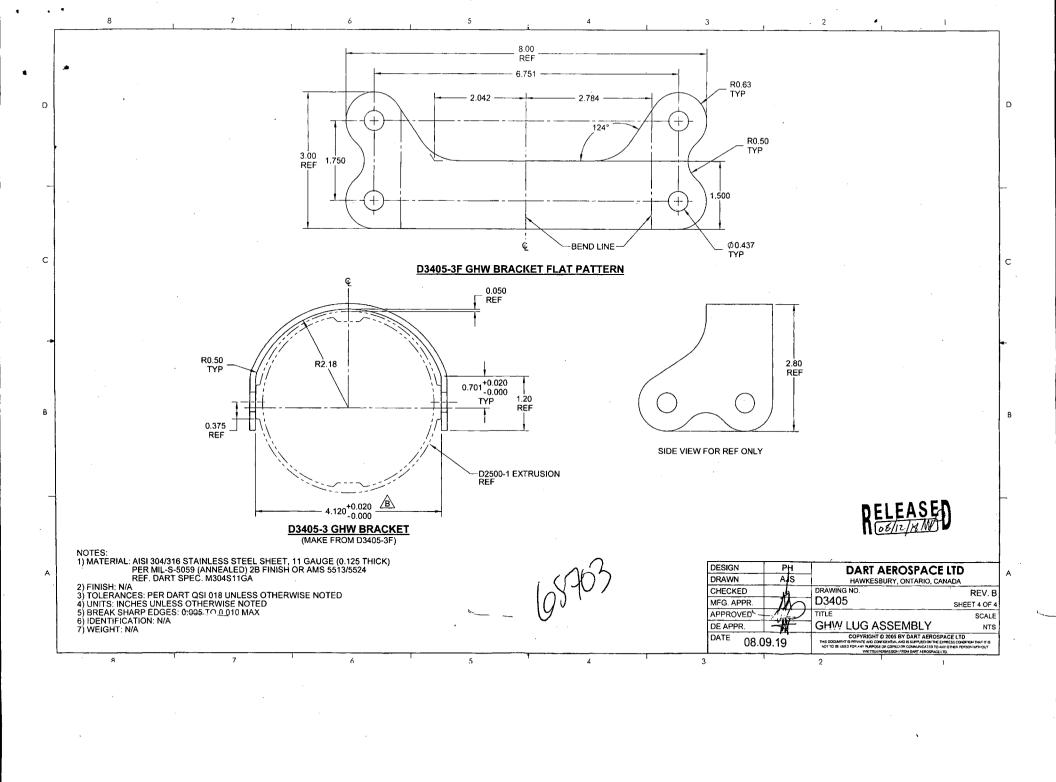
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DATE	STEP	Description of NC Section A	Corrective Action Description		Section B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
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	1246									
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DART AEROSPACE LTD	Work Order:	65103
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prote	otype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.439	¥		V BOZ	
1.50	+/-0.030	1.510	X		ν	
1.750	+/-0.010	1.748	8		V	
R0.63	+/-0.030	, ,63	×		R.G.	
3.00	+/-0.030	3,000	>		V	
8.00	+/-0.030	8.001	×		V	
6.751	+/-0.005	6,753	8		V	
						1
-						=
		,		·		
						·
						,

Measured by:	iB.	Audited by:	Prototype Approval:	N/A
Date:	11-1-24	Date: 1/01/71/	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue P/O D3405-043	KJ/JLM	
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD #	Sul
	· 		- 1	